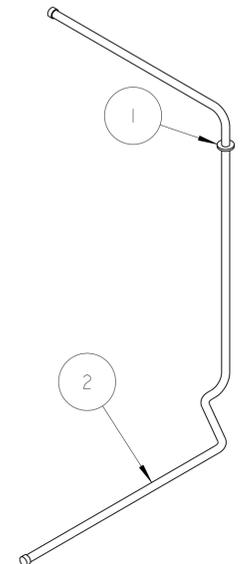
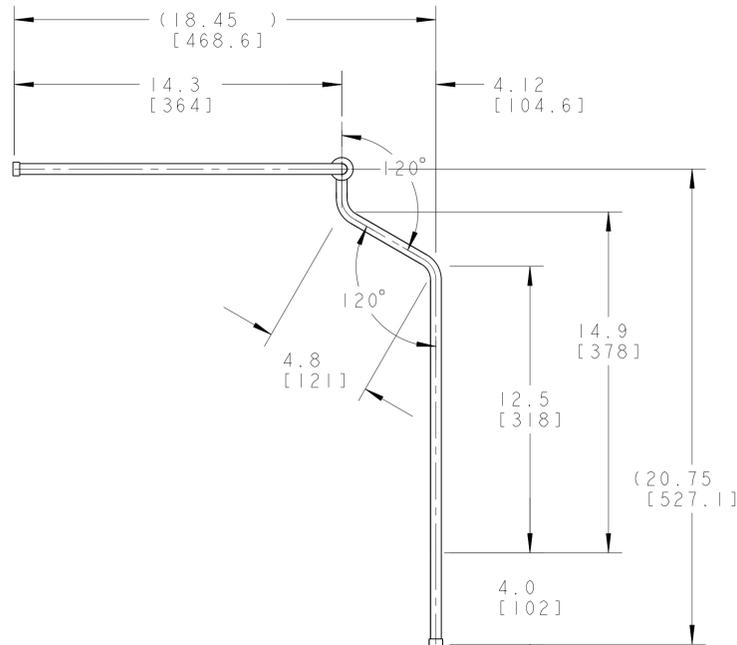


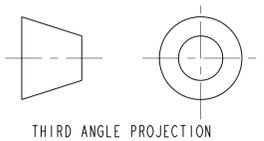
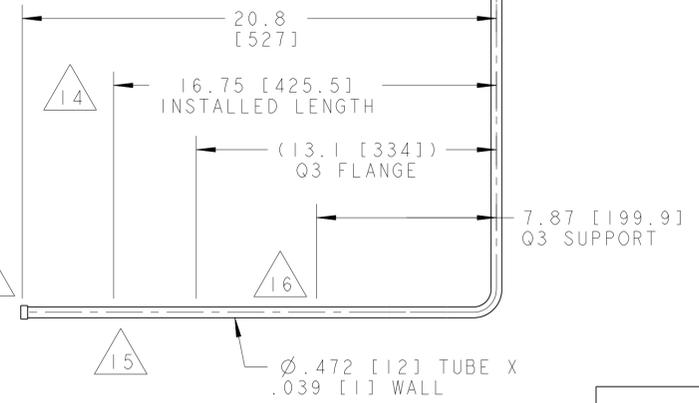
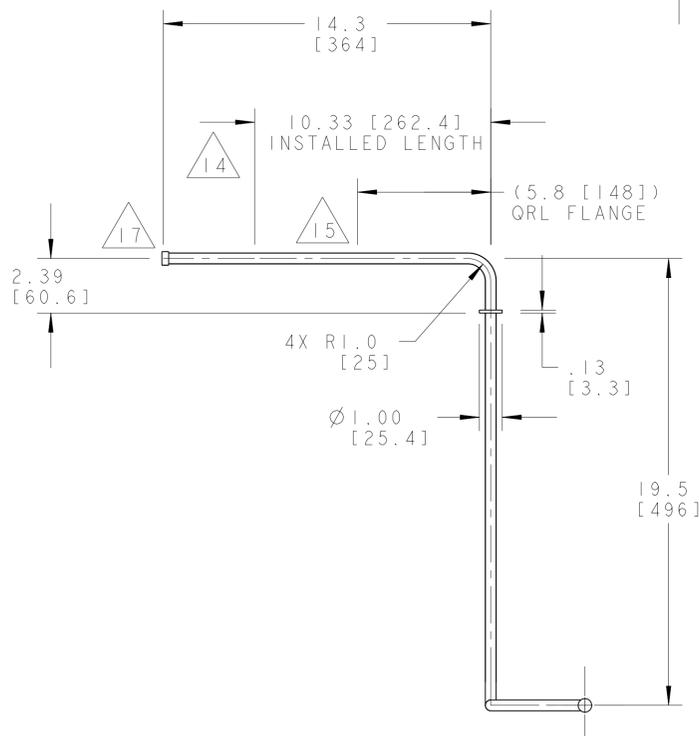
NOTES: (UNLESS OTHERWISE SPECIFIED)

- THIS IS A CRYOGENIC VACUUM COMPONENT.
- WELDING PROCEDURE: PER VENDOR SPECIFICATION WITH LBNL APPROVAL.
- CLEANING PROCEDURE : PER VENDOR SPECIFICATION WITH LBNL APPROVAL.
- PACKAGING AND STORAGE PROCEDURE OF THE COMPONENTS: PER VENDOR SPECIFICATION WITH LBNL APPROVAL.
- DIMENSIONS AND TOLERANCING PER ANSI Y14.5M-1982. UNITS ARE IN INCHES [mm] UNLESS OTHERWISE SPECIFIED.
- USE OF SULFUR OR SILICONE BEARING OILS, LUBRICANTS, OR COOLANTS ARE STRICTLY PROHIBITED.
- USE OF RESIN OR RUBBER BONDED ABRASIVES UNDER POWER IS STRICTLY PROHIBITED. USE VITREOUS BONDED ABRASIVES ONLY.
- VENDOR SUGGESTED CHANGES TO WELD PREPS; SUBJECT TO LBNL APPROVAL.
- FITTINGS MAY BE USED IN PLACE OF BENDS; SUBJECT TO LBNL APPROVAL.
- VENDOR SUGGESTED CHANGES TO TOLERANCES TO FACILITATE FABRICATION OR ASSEMBLY; SUBJECT TO LBNL APPROVAL.
- REMOVE ALL THE BURRS AND REAM THE ENDS FOR CIRCULARITY AND CLEAN ENDS.
- TUBE END SURFACE MUST BE PERPENDICULAR TO THE TUBE AXIS WITHIN +/- .010.
- PERFORM ACCEPTANCE TESTS PER LBNL SPECIFICATION M989. (B)
- A MARK DESIGNATING THE INSTALLED LENGTH WILL BE UTILIZED DURING FINAL INSTALLATION OF THE FEEDBOX ASSEMBLY. MARK, SCRIBE OR ETCH THIS LOCATION IN A PERMANENT MANNER, SUBJECT TO LBNL APPROVAL, TO AN ACCURACY OF ±0.063".
- PROVIDE A MINIMUM LENGTH OF 4.0" OF STRAIGHT, SMOOTH PIPE ON THE INDICATED SIDE OF THE INSTALLED LENGTH MARK FOR PIPE WELDING DURING FINAL INSTALLATION OF THE FEEDBOX ASSEMBLY.
- PIPE MUST BE STRAIGHT AND SMOOTH (NO BUMPS) FOR 1.5" ON EITHER SIDE OF THE CENTER-PLANE OF THE SUPPORT. (B)
- CAP BOTH ENDS OF PIPE TO FACILITATE ACCEPTANCE TESTS. (B)

| | | | | | |
|----------|---------|------|---------------------|------|----------|
| DWG. NO. | | SIZE | | REV. | SH. |
| 2513034 | | B | | 1 | |
| 2 | - | 1 | TUBE, PER ASTM A269 | | SS 304L |
| 1 | - | 1 | COLLAR | | SS 304L |
| ITEM | PART NO | REQD | DESCRIPTION | | MATERIAL |



SCALE 3/16



| | | | | | | | | | |
|--|--|---|--|----------------------------|--|-------------------------|--|-------------------------------------|--|
| TOLERANCES | | UNLESS OTHERWISE SPECIFIED | | SHOP ORDERS | | SER. NO. - | | ERNEST ORLANDO LAWRENCE | |
| X.X ± 0.1 | | FRAC. ± 1/64 | | ACCT. NO. - | | NO. - | | BERKELEY NATIONAL LABORATORY | |
| X.XX ± 0.03 | | Angles ± 1.00° | | DEL. TO - | | DATE ISSD - | | UNIVERSITY OF CALIFORNIA - BERKELEY | |
| X.XXX ± 0.010 | | FINISH 125 _{µm} | | DATE RECD - | | DATE RECD - | | LHC IR FEEDBOX | |
| DO NOT SCALE PRINT | | THREADS ARE CLASS 2 | | SURFACE TREATMT | | IDENT. METHOD | | CRYOGENICS | |
| CHAMFER ENDS OF ALL SCREW THREADS 30° | | CUT ROUNDS, 1.5 THREAD RELIEF ON MACHINED THREADS | | PROJECT NUMBER | | PROJECT NAME | | PIPE, CYI | |
| BREAK EDGES .016 MAX. ON MACHINED WORK | | REMOVE BURRS, WELD SPLATTER & LOOSE SCALE | | BY: M. KNOLLS | | DATE: 27-Mar-02 | | MICROFILMED: - | |
| IN ACCORDANCE WITH ASME Y14.5M & B46.1 | | INITIAL RELEASE | | BY: Jon Zbasnik/S.Virostek | | DATE: 01-Nov-02 | | DWG. TYPE: ASSEM | |
| REV. DWG. CHK. ZONE. DATE. CHANGES | | A ARH SPV 11-01-02 | | BY: Jon Zbasnik/D.Oshatz | | DATE: 08-AUG-02 | | SHOWN ON: - | |
| | | B ARH SPV 01/09/03 | | PATENT CLEAR: - | | DESIGN ACCT. NO. Z5LCE2 | | CATEGORY CODE: LH2003 | |
| | | REVISED DRAWING NOTE 13, 16 & 17, MINOR DRAWING DIMENSIONAL CHANGES | | SCALE: 1/4 | | DO NOT SCALE PRINTS | | SHEET 1 OF 1 | |
| | | INITIAL RELEASE | | DWG. NO. 2513034 | | SIZE B | | REV. - | |